

February 6, 2001  
00331 - 01 G/hw

**Windmoeller & Hoelscher KG**  
**D - 49525 Lengerich / Westf.**

---

Process for Manufacturing Side Fold Sacks made of Plastic Film

---

**Patent Claims**

1. Process for manufacturing side fold sacks from a flat lying segment of a web of plastic tubular film, provided with side folds,  
  
characterized in that one end of the segment of a plastic tubular film is provided in such a manner with a staggered cut or a staggered detachment along a perforation that in a top view of the stagger the rear wall projects beyond the front wall and that the stagger is provided with an application of adhesive as far as into the area of a fold line, which is located in the area of the edge of the front wall that has been cut free, and the stagger is folded over the fold edge onto the front wall.
2. Process, as claimed in claim 1, characterized in that the rear wall projects, in a top view of the stagger, beyond the side folds; and the side folds project beyond the front wall.

3. Process, as claimed in claim 1 or 2, characterized in that in the graduation the bottom layers of the side folds project beyond the upper layers of the side folds.
4. Process, as claimed in any one of the claims 1 to 3, characterized in that the perforation lines are affixed on a flat lying plastic web at intervals equal to the length of the segments of a web of plastic tubular film, before said segments are added to a side fold tubular web by folding the web sides so as to overlap and simultaneously inserting side folds and affixing a center weld, which runs lengthwise.
5. Process, as claimed in claim 4, characterized in that, starting from the part that forms the rear wall, the perforation lines can pass in steps over those parts that form the side folds into the part that forms the front wall, and that the transverse segments of the graduated perforation line are parallel to each other.